

Work Order ID 64452



Page 1

Monday, December 06, 2010 10:21:11 AM

Item ID: D3557-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 12/6/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-12-06 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3557	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3557 ☒ Dwg Rev: A ☐ Prog Rev: A

6061 .125

☐

****Ensure Grain Direction is Correct**** ☐ 2-Deburr if necessary

B 10-12-14

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 10-10-14

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8101215

(X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3557

SB 11/01/03

(12)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SB 11/01/03

(12)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

SB 11/01/01

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID:	D3557-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket					
Start Date:	12/6/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	12/13/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M115951</i> Memo START TIME: <i>3:20</i> □ COVEN TEMPERATURE: <i>3:20</i> □ FINISH TIME: <i>3:50</i>	0.00 0.00				<i>12</i>	<i>BR</i>	<i>11-01-14</i>	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>=> M 11/01/05</i>		<i>12</i>	<i>0</i>		
180 Packaging Packaging	Identify as per dwg & Stock Location: <i>067</i> Memo	0.00 0.00					<i>P 11/01/06</i>	<i>(12)</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 64452

Monday, December 06, 2010 10:21:11 AM

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Item ID: D3557-1

Accept

Revision ID:

Item Name: Bracket

Start Date: 12/6/2010 Start Qty: 6.00

Required Date: 12/13/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ck 11/01/06
UMF

11-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:21:15 AM

Page 1

Work Order ID: 64452



Parent Item: D3557-1



Parent Item Name: Bracket


Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125  6061-T6 .125 Sheet		Purchased	No			100	sf	70.5600	0.0343	0.216632	42	12-10-14	

Location

Loc Qty

Loc Code

MAT21

70.56

113608

70.56

113608

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

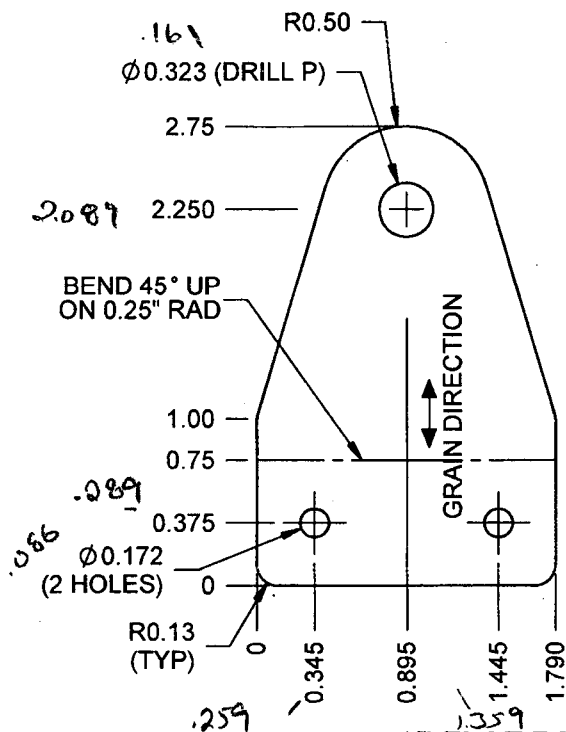
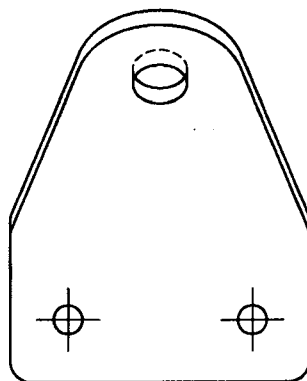
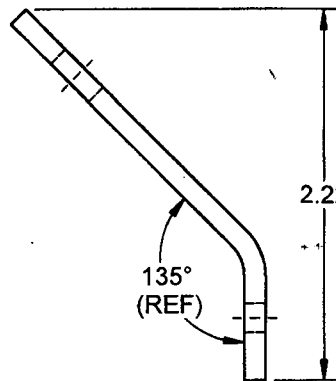
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3557	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE BRACKET		SCALE 1:1
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	

**D3557-1F FLAT PATTERN****D3557-1 BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3557-1 USING FINE POINT PERMANENT MARKER

RELEASED
06.10.13

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DART AEROSPACE LTD		Work Order: 64853
Description: Bracket		Part Number: D3557-1
Inspection Dwg: D3557	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.172	+0.005/-0.001	.173	✓		✓ 1302	
Ø0.323	+0.006/-0.001	.323	✓		✓	
2.75	+/-0.030	2.753	✓		✓	
1.790	+/-0.010	1.796	✓		✓	
0.345	+/-0.010	.347	✓		✓	
1.445	+/-0.010	1.443	✓		✓	
0.375	+/-0.010	.376	✓		✓	
2.250	+/-0.010	2.253	✓		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 10-12-14	Date: 10/12/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	B